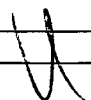



Date: Tuesday, 27/01/2009 3:06:02 PM
 User: Linda Lacelle

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: REWORK
Job Number	: 45297		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D36871
This Issue	: 27/01/2009	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: D3687-1
First Issue	: 27/01/2009	Project Number	:
Previous Run	: 00015	Drawing Revision	:
	Type : MACHINED PARTS	Material	:
Written By	: 	Due Date	: 28/01/2009
Checked & Approved By	: 	Qty:	2 Um: Each
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
----------------	------------------------------	----------------------

1.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING
 PULL FROM CALGARY (QRTN) *u 09.01.21*
 D3687-1 B36808

 SEND TO METCOR FOR HEAT TREAT
 TO CONDITION H900
 CERTIFICATE REQ'D
 P.O. *8023 C209101121 6*

2.0	D36871	MOUNT
-----	--------	-------


Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)
 MOUNT

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------

**Comment:** PACKAGING RESOURCE #1
 RECEIVE AND INSPECT FOR TRANSIT DAMAGE
 ENSURE C OF C ATTACHED
C209101127 2

4.0	QC4	INSPECT 100% KITS FOR COMPLETENESS
-----	-----	------------------------------------

**Comment:** INSPECT 100% KITS FOR COMPLETENESS*S 0910127 2*

5.0	PG	PURCHASING
-----	----	------------

**Comment:** PURCHASING
 Issue P/O: *8084*
 LPI Per ASTM 1417 LEVEL 2
JUP 09.01.28 2

Date: Tuesday, 27/01/2009 3:06:02 PM
User: Linda Lacelle

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: REWORK

Job Number: 45297

Part Number: D36871

Job Number:



Seq. #:

Machine Or Operation:

Description :

Certificate of conformaty is required

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

09/01/28

7.0

QC5

INSPECT WORK TO CURRENT STEP



ml 09 01 28



(2)

Comment: INSPECT WORK TO CURRENT STEP

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock USING NEW B/N

Location: _____

D3684-043 B 45215

9.0

QC21

FINAL INSPECTION/W/O RELEASE



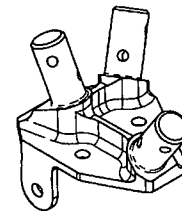
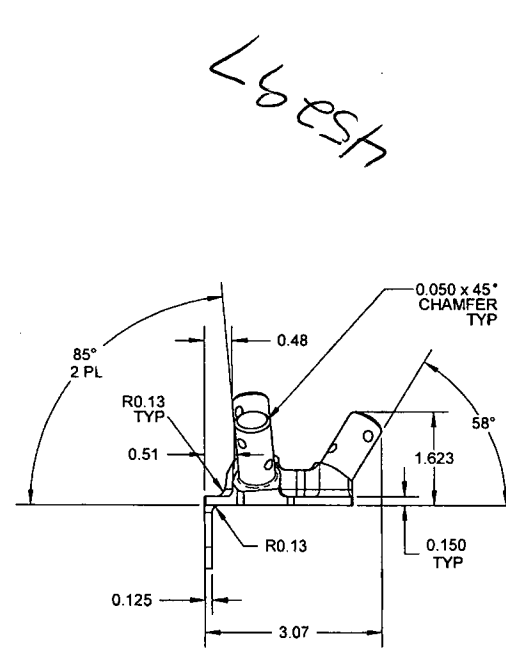
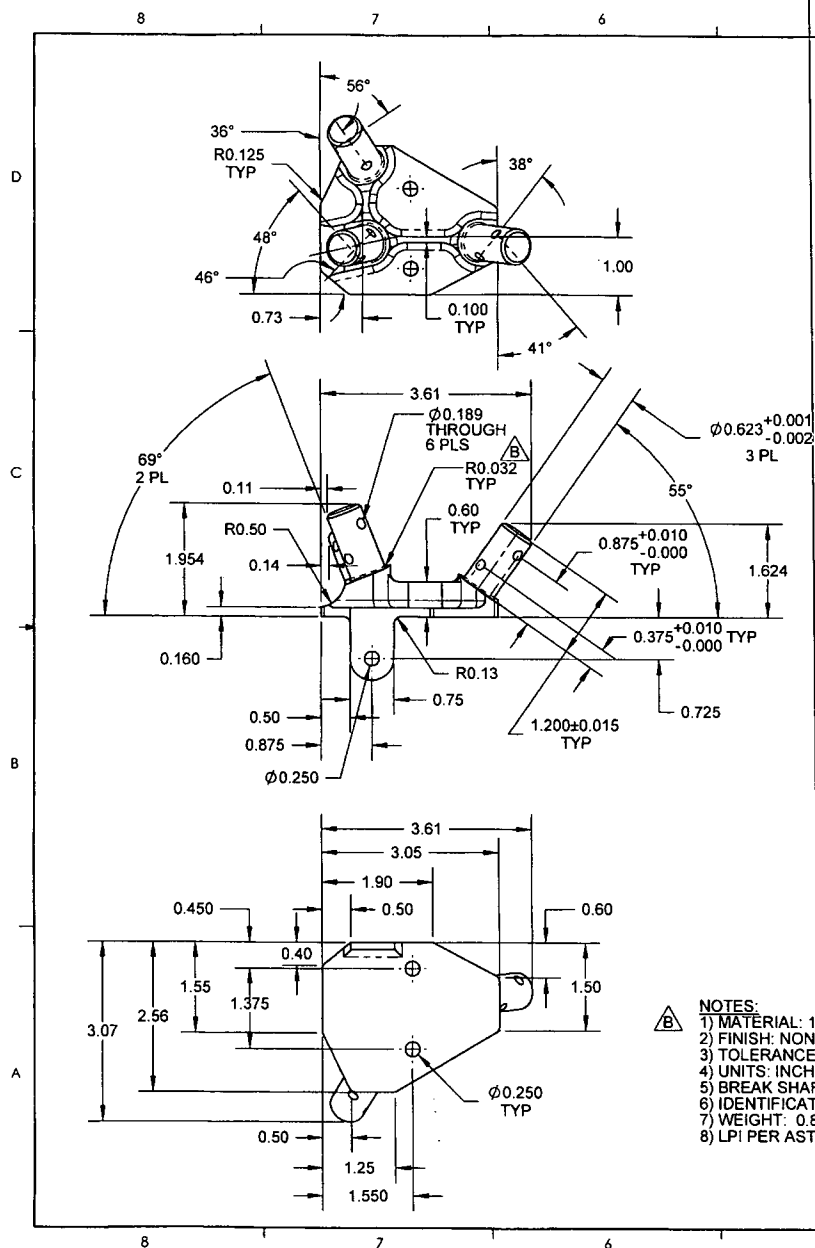
Comment: FINAL INSPECTION/W/O RELEASE

09/01/29

Job Completion



MF 09-01-28

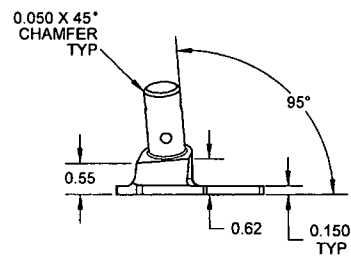
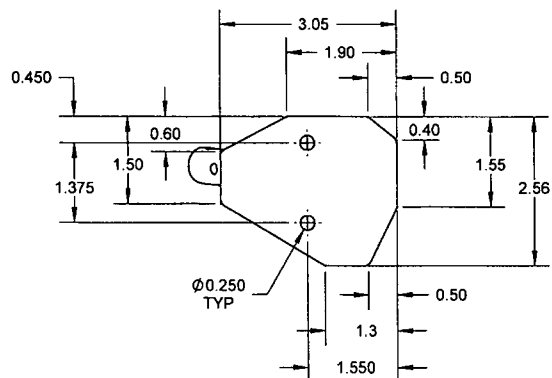
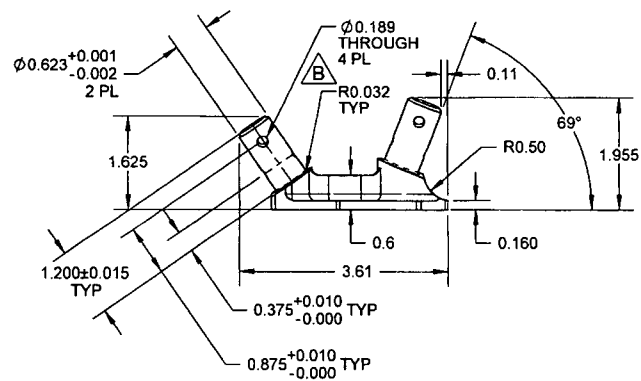
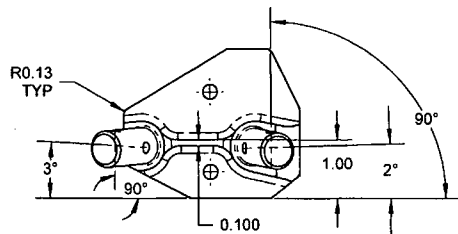


D3687-1 MOUNT

RELEASED
08/12/15

- NOTES:**
 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 2) FINISH: NONE
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 6) IDENTIFICATION: NONE
 7) WEIGHT: 0.81 lb
 8) LPI PER ASTM 1417 LEVEL 2





B	CHANGE TO 17-4PH H-900 (ZN A6-1 & B3-2); R032 WAS R0.015 (ZN C7-1 & C7-2); REFORMATTED TO CURRENT DWG STANDARDS	RF	08.11.24
A	NEW ISSUE	RF	08.03.12
REV	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. #
MFG. APPR.	<i>[Signature]</i>	D3687	SHEET 1 OF
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	



- NOTES:**
- 1) MATERIAL: 17-4PH SS BAR PER AMS 5643, H-900 CONDITION
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.64 lb
 - 8) LPI PER ASTM 1417 LEVEL 2

D3687-3 MOUNT

RELEASED
08/12/15

DESIGN	RF	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		D3687	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		MOUNT	NTS
DATE	08.11.24	COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

Metcor Inc.

Metcor Inc.
560, boul. Arthur-Sauvé
St-Eustache (Québec) J7R 5A8
Page 1 of 1
Tél: (450) 473-1884
Fax Administration: (450) 491-5498
Fax Production: (450) 491-6454

Rapport d'inspection

Order	Load
145132	1

Customer 215
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Shipped To:
DART AEROSPACE
1270 ABERDEEN
HAWKESBURY

ON K6A 1K7

Customer PO / PO du Client	Customer Shipper No.	Material Type / Material	Mat'l Heat Code	Lot Number
po00008023		17-4PH		

PROCESSING SPECIFICATIONS

AGE HARDEN

CONDITION H 900

Requirement
HARDNESS

Specified
40 - 47 HRC

Tests Performed
4

Test Results
42 - 42,5 HRC

S
09/01/07

Quantity	Weight	Part Number / Part Description
4	3	d3687-1 & d3687-3 1 boîte de carton eps

C.O.D.

COMMENTS

INSPECTOR:

André J.



DATE: 2009-01-25



BILL CERTIFICATE OF QUALITY

DIR 50045 2.1.3
EN 10284 2.1.3

ELABORADO ON: 10.02.2006

WONDER: 1212011 REV:000

SHEET: .1 / 2

DATE: 10.02.2006

CUSTOMER:

INVOICE ORDER: AC0835

MATERIAL SPECIFICATION: QAD 40 REV.3

GRADE: 17418

ASTM A564
ASTM A663

PLANT: BASIC ELECTRIC FURNACE + A.O.D. QAD REFERENCE: 22192

ITEM	SIZE	LENGTH	WEIGHT
3	15000 30 20000 30	4.000 / 4.000 MT.	36279 36279

ITEM	WEIGHT
3	35210 35210

CHEMICAL COMPOSITION (%) : LAVE: O: PROPER:)													
1. HOT													
1.36279	C	0.051	Si	0.250	P	0.0026	S	0.0010	Mn	4.65	Cr	15.55	Mo
	V		20		N				Co		As	0.22	Al
1.36279	0.043	0.003	0.110	0.0021	0.020	0.0055	0.0007	0.007	0.030	0.0165	Ca	3.15	Sr
											N		0.010

MECHANICAL TESTING

TENSILE TEST									
HEAT	ITEM	END (°C)	RD 0.2%	RD 1.0%	RM	A1(%)	A2(%)	ELONG. (MM)	RED. AREA (%)
36279	2	RT						10	11
36279	3	RT						28	29

SURFACE FINISH

ITEM 2 FULLY SURFACE GRIND
ITEM 3 FULLY SURFACE GRIND

HEAT TREATMENT
FULLY ANNEALED

OTHER REQUIS

THIS MATERIAL WAS MANUFACTURED ACCORDING OUR QUALITY SYSTEM APPROVED AND REGISTERED TO ISO 9002.

ULTRASONIC TESTED ACCORDING TO

ITEM	CLASS	STANDARD
2	FHM-6	A-288/A-715 Q&T
3	FHM-6	A-288/A-715 Q&T

EUROPEAN STEEL SALES LTD
SPECIFICATION CHECKED BY
TONY HARRISON, AND IS IN
PURCHASE WITH OUR

DATE REGISTERED
07/11/06



ACERALAVA S.A. is a company registered in the Commercial Register of Madrid, Spain, under the name of ACERALAVA S.A. with the number 280111111. The company is a public limited company with its registered office in Madrid, Spain. The company is a member of the ACERALAVA group of companies.

ACERALAVA
ACERLA DE ALAVA S.A.
Directorio de Cerdeña S.A.

JART Aerospace
1270 Aberdeen
New Kensington
K6A K7

N° DE COMMANDE - ORDER NO.		DÉP. - DEPT.	DATE 09.01.21
VENDU À - SOLD TO		EXPÉDIÉ À - SHIP TO	Metco! St. Eustache
ADRESSE - ADDRESS		ADRESSE - ADDRESS 560 Arthur Avenue QC. J7R-5A8	

DATE D'EXPÉDITION - SHIPPING DATE	VIA 210 8023	CONDITIONS - TERMS	N° D'ENR. DE TAXE - TAX REG. NO.	VENDEUR - SALESPERSON
				450-473-1884

2 D3687-1
2 D3687-3

Next treat to wind. H900

~~per AMS 7/3~~

Str in excess of 190 Ksi

Fty in excess of 170 Ksi

Next treat certificate

< req'd

Please return best by
Tuesday 27/01/21
Fedex out # 15170324-0

Thank You!

Luc

CERTIFICATE OF CONFORMITY
REQ'D UPON DELIVERY

100628

SIGNATURE

N° LIC. - LIC. NO.

TPS/GST

TVP/PST

TOTAL

From:
To:
Cc:
Subject:

Jean-Luc Menard [jmenard@dartaero.com]
January 19, 2009 3:05 PM
Linda Lacelle (Linda Lacelle)
David Shepherd (David Shepherd)
D3687-1/-3 BRACKETS

Attachments: image001.jpg



image001.jpg (2
KB)

Linda,

Could u pls contact the heat treater and ask if we can treat the existing brackets to
CONDITION H-900 MADE FROM 17-4ph.

If they can pls send them over asap.

Thx

JLM

Jean-Luc Menard

Production Engineering Coordinator

1270 Aberdeen Street

Hawkesbury Ontario

Canada K6A 1K7

Tel: (613) 632-5200 Ext 227

<mailto:jmenard@dartaero.com> jmenard@dartaero.com

227

Date: Tuesday, 27/01/2009 11:44:13 AM

User: Melanie Fauteux

JOB HISTORY : DETAIL

Job Number	: 36808	Customer	: Dart Helicopters Services
Estimate Number	: 13130	DWG Name	: BRACKET
Purchase Order #	:	Part Number	: D36871
Complete Date	: 31/03/2008 11:59:59	DWG Number	: D3687 U/R
		Rev.	: U/R

DUE DATE	ORDERED	DELIVERED
29/01/2008	3	3

1.0 OUTSIDE SERV.30 Sub-contr./External OP.

DATE	EMPLOYEE	TYPE	Qty	COST	
06/03/2008			2.000	\$854.50	VC-GLO P.O.: PO00005477
10/04/2008			3.000	\$76.50	VC-ACU P.O.: PO00006096

Subtotal: QTD: 0 CTD: 5 \$931.00

2.0 M174B3937X4750-17-4 SS Bar 3.937 x 4.750 INVENTORY

DATE	EMPLOYEE	TYPE	Qty	COST	
15/02/2008	LACE01: Lacelle, Linda	M174B3937X4750	1.050	\$457.34	Lot # 106857 Qty. 1

Subtotal: QTD: 0 CTD: 1 \$457.34

	TIME	COST
Machine Time:	0.00	\$0.00
Labor:	0.00	\$0.00
Sub-contract (external Op.):		\$931.00
INVENTORY ITEM:		\$457.34
SUB-COMPONENT (SUB-JOB):		\$0.00
Total:		\$1388.34

COST PER UNIT: \$462.78

Lacelle

From: David Shepherd [dshepherd@dartaero.com]
Sent: January 21, 2009 12:04 PM
To: 'L Lacelle'
Cc: 'Bill Beckett'; 'Jean-Luc Menard'
Subject: RE: engine mount parts

Yes ... as long as the final condition is H900, this is acceptable to me.

David

From: L Lacelle [mailto:llacelle@dartaero.com]
Sent: Wednesday, January 21, 2009 9:39 AM
To: 'David Shepherd'
Cc: 'Bill Beckett'; 'Jean-Luc Menard'
Subject: engine mount parts

Metcor can heat treat the old parts(D3687-1/-3) to condition H900 per ~~AMS2759/3~~, is this acceptable?

Thank You,
Linda Lacelle
Production Manager
Dart Aerospace Ltd

No virus found in this incoming message.

Checked by AVG.

Version: 7.5.552 / Virus Database: 270.10.10/1904 - Release Date: 1/20/2009 7:49 AM

No virus found in this outgoing message.

Checked by AVG.

Version: 7.5.552 / Virus Database: 270.10.10/1906 - Release Date: 1/21/2009 7:07 AM



LIQUID PENETRANT TEST REPORT

P- 14931

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE JAN. 20-2009 TIME AM ☒ PM ☐
ATTENTION LINDA ACUREN JOB NO. 180-09-001282
ADDRESS 1270 ABERDEEN ST PO/VO NO. 8084
HAWKES BURY, ONT. K6A-1K7 WORK LOCATION MAIN SHOP - HAWKESBURY
ACCEPTANCE STD. ASTM 1417 REV./DATE 2007
PROJECT F.P.I. ON MACHINED PARTS AND CROSS TUBES.
ITEM(S) EXAMINED 42 MACHINED PIECES.
3 CROSSTUBES 100% EXTERNAL AND ONE CROSSTUBE REEXAMINE

JOB DESCRIPTION WET FLUORESCENT LIQUID PENETRANT INSPECTION
PROCEDURE No. LT-XXXX REV./DATE 2007 TECHNIQUE No. LT-XXXX-XXX REV./DATE 2007
PART NO. WET FLUORESCENT LIQUID PENETRANT INSPECTION MATERIAL ALUMINUM THICKNESS 0.01
SCOPE CARRIED OUT ON 100% EXTERNAL.

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNAFLUX BLACK LIGHT S/N 8171 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2L 67 MINIMUM DWELL TIME 25 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER 1120 MINIMUM DRY TIME >10 MIN. OTHER
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 09-01-28 CAL DUE DATE FEB-09
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☐ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/20°F ☐ -4°C/20°F TO 10°C/50°F ☐ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

ITEM	COMMENTS	ACCEPT	REJECT
1	JOB # 44214	✓	
1	45066	✓	
1	44215	✓	
1	44944	✓	
2	45299	✓	
10	44824	✓	
6	44687	✓	
2	45297	✓	
10	44823	✓	
6	44686	✓	
6	44685	✓	

ALL ITEMS FOUND
ACCEPTABLE FOR JOB # 180-09-001282

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

CLIENT REPRESENTATIVE Matthew Munn SIGNATURE Matthew Munn DTR #
TECHNICIAN (SIGNATURE): Mike Johnston SIGNATURE Mike Johnston REPORT REVIEWED BY:
NAME (PRINT): Mike Johnston NAME INITIALS
1ST TECHNICIAN 2ND TECHNICIAN
CGSB LEVEL II SNT LEVEL II CGSB LEVEL II SNT LEVEL II
CGSB REG. NO. 6066 CGSB REG. NO. 6066